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D3914-041
Job Sheet 199709



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/30/19

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/30/19	9/30/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/30/19	9/30/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 50	9-89	
							QC 9 - 9		
120	QC 5	1 pcs	9/30/19	9/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

Plex 8/29/19 12:47 PM Dart.lajeunesse.marie

130 Powdercoat - 4 Black Sand -
B4B1
pcs

9/30/19

0.00 0.40

START: 8:55 AM, 300° FINISH: 9:25

135 QC 3

1
pcs

9/30/19

0.00 0.00

QC 5 - 68
QC 5 - 9
QC 5 - 50
QC 5 - 30
QC 5 - 40
QC 5 - 61
QC 5 - 81Powdercoat - 1 - B4B
Powdercoat - 2 - B4B
Powdercoat - 3 - B4B
Powdercoat - 4 - B4B

BK 19-9-3

QC 3 - 10
QC 3 - 13
QC 3 - 15
QC 3 - 17
QC 3 - 18
QC 3 - 2
QC 3 - 28
QC 3 - 3
QC 3 - 30
QC 3 - 34
QC 3 - 36
QC 3 - 41
QC 3 - 51
QC 3 - 58
QC 3 - 59
QC 3 - 68
QC 3 - 9
QC 3 - 40
QC 3 - 19
QC 3 - 43
QC 3 - 24
QC 3 - 61
QC 3 - 81

AL 19-10-3

DAS
15
9-89140 Handfinish - 3-1- WingWalk-
B4B1
pcs

9/30/19

0.00 0.80

Handfinish - 3 - 1 -
B4B
Handfinish - 3 - 2 -
B4B
Handfinish - 3 - 3 -
B4B
Handfinish - 3 - 4 -
B4B
Handfinish - 3 - 5 -
B4B

AL 19-10-03

150 QC 3

1
pcs

9/30/19

0.00 0.00

QC 3 - 10
QC 3 - 13
QC 3 - 15
QC 3 - 17
QC 3 - 18
QC 3 - 2
QC 3 - 28
QC 3 - 3
QC 3 - 30
QC 3 - 34
QC 3 - 36
QC 3 - 41
QC 3 - 51
QC 3 - 58
QC 3 - 59
QC 3 - 68

3EB 19-10-03

DAS
59
9-89

160 Packaging 3-1 - Stock - B4B

1
pcs

9/30/19

0.00 0.00

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
B4BPackaging 3 - 20 -
B4BPackaging 3 - 21 -
B4BPackaging 3 - 22 -
B4BPackaging 3 - 23 -
B4BPackaging 3 - 24 -
B4BPackaging 3 - 25 -
B4BPackaging 3 - 26 -
B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4B

Packaging 3 - 33 -

14-16-03

				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	9/30/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 04 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 1139015 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

MU #012161

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 200407
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 210864
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 214596
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	S 193147
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	S 215570
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 208015
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 172801
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 210776

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3914-1	2	8	0
	D3914-7	2	10	0
	D4016-3	3	65	0
	D4018-5	9	11	0
	D4020-5	1	9	0
	D4021-3	1	25	0
	D4035-043	2	6	0

Part Specifications

Specifications could not be found.



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Plex 8/29/19 12:47 PM Dart.lajeunesse.marie

Container No: S218232



Part: D3914-041

Job No: 199709

Serial No/Batch: S218232

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/30/19

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐	
		Bending ☐		Misaligned/off center ☐		Folio/Program ☐	
		Crushing ☐		BOM/Route ☐		Grain Direction ☐	
		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	
		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐	
		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐	
Other/Details: _____							
		Completed By _____					
		Lead hand / Supervisor _____					
		QC / QA Coordinator _____					